

**Work Order ID 114984****\*114984\***

Page 1

Monday, March 17, 2014 2:37:44 PM

Item ID: D3685-041      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Bipod Mount Ass'Y  
Start Date: 3/17/14      Start Qty: 1.00      **\*1\***      Cust Item ID:  
Required Date: 3/17/14      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan: AP      Date: 14-03-18      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	F

100	Pick Kit	0.00
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**\*100\***

Packaging

Memo

0.00

Packaging

110

**\*110\***

Small Fab

Small Fab

Small Fab

Memo

0.00

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

\*\*\*AFTER FINISH DRILLING AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP\*\*\*

2-Assemble D3684-049/-047 & D3687-3 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

MAGNOBOND BATCH: \_\_\_\_\_

Hysol: M120703

14-05-14

FF  
14-05-15

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 114984

**\*114984\***

Page 2

Monday, March 17, 2014 2:37:44 PM

Item ID: D3685-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bipod Mount Ass'y

Start Date: 3/17/14

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/17/14

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS

**\*120\***

0.00

27

QC

Memo

0.00

3-89

Quality Control

14/5/15

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*130\***

0.00

Packaging

Memo

Packaging

PNP 11/4/73

14/5/15

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

0.00

QC

Memo

Quality Control

14/5/20

14-5-16

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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### FAULT CATEGORY

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# Picklist Print

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Page 1

Work Order ID: 114984

\*114984\*

Parent Item: D3685-041

\*D3685-041\*

Parent Item Name: Bipod Mount Ass'Y

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL  
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP  
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC  
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3684-047 Manufactured No

Each 4.0000

1

\*D3684-047\*

\*\*

FF 14-05-14

Fwd Leg Ass'Y

Location

Loc Qty

Loc Code

st200

4

~~B-107593~~

102870

1

108000

1

97521

2

D3684-049 Manufactured No

Each 2.0000

1

\*D3684-049\*

\*\*

FF 14-05-14

Aft Leg Ass'Y

Location

Loc Qty

Loc Code

st200

2

~~7~~

101594

2

D3687-3 Manufactured No

Each 13.0000

1

\*D3687-3\*

\*\*

FF 14-05-14

Mount

Location

Loc Qty

Loc Code

GA

13

83611

4

93757

9

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Picklist Print

Page 2

Monday, March 17, 2014 2:37:44 PM

Work Order ID: 114984

**\*114984\***

Parent Item: D3685-041

**\*D3685-041\***

Parent Item Name: Bipod Mount Ass'Y

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

HL32PB8-14

Purchased

No

Each

220.0000

4

**\*HI 32PB8-14\***

**\*\***

FF 14-05-15

Pin

Location

Loc Qty

Loc Code

ST284

220

125436

20

m128179

100

m128454

100

HL86-8

Purchased

No

Each

146.0000

4

**\*HI 86-8\***

**\*\***

FF 14-05-15

Collar

Location

Loc Qty

Loc Code

ST284

146

m126267

46

m127815

100

Monday, March 17, 2014 2:37:44 PM

Shop Packet Print

Page 2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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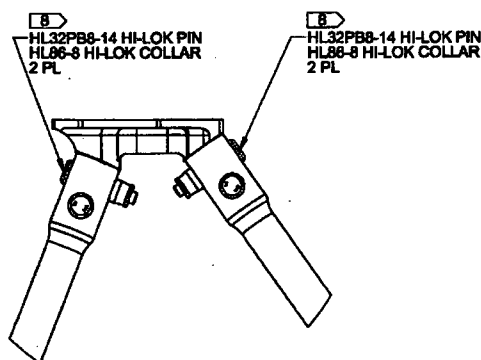
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

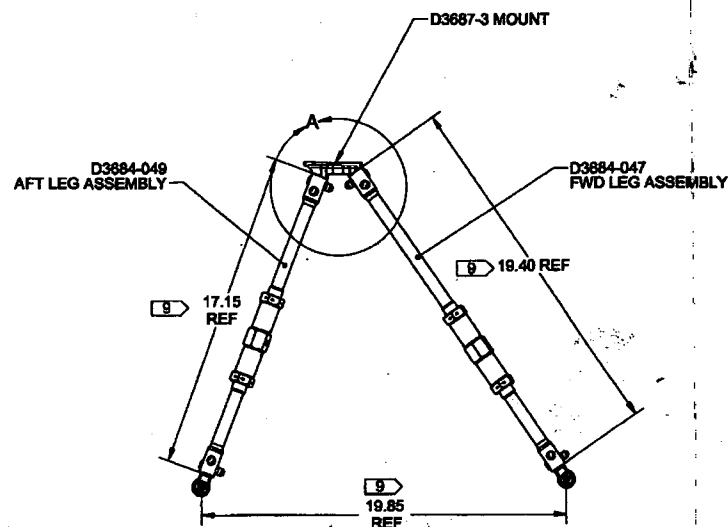
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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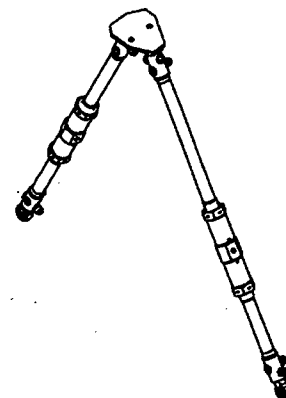
ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D3685-041	BIPOD MOUNT ASSEMBLY
1	1	D3687-3	MOUNT
2	1	D3684-047	FWD LEG ASSEMBLY
3	1	D3684-049	AFT LEG ASSEMBLY
4	4	HL32PB8-14	HI-LOK PIN
5	4	HL86-8	HI-LOK COLLAR



**DETAIL A**  
SCALE 3X



**D3685-041 BIPOD MOUNT ASSEMBLY**



**RELEASED**  
2013-12-01

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 ( FINE POINT PAINT MARKER )
  - 7) WEIGHT: 6.68 lbs
  - 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA/0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA/0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-3 USING HYSOL EA834NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES. HI-LOK PIN ORIENTATION AS PER DETAIL 'A'.
  - 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

F	ADD DETAIL A. REVERSE THE INSTALLATION ORIENTATION OF HI-LOK PINS TO FACILITATE ASSEMBLY PROCEDURE. CORRECT BOM TABLE	DB	13.11.18
E	REMOVE AN3C-12A BOLT, D3682-1 SPACER AND M821043-3 NUT. REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN CS-1, ZN CS-1); RE-FORMAT NOTES SECTION AS PER QSI 043. CHANGE ASSEMBLY ADHESIVES, NOTES (ZN AS-1). CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE, (ZN D8-1) REF RCR 12-2074	DB	12.12.05
F	17.15 WAS 17.27 (ZN B8-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN AS-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.85 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	AD		
APPROVED	SH		
DE APPR.			
DATE	13.11.18		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3685** REV. F  
TITLE **BIPOD MOUNT ASSEMBLY** SCALE NTS

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